

Date: Friday, 7/4/2008 12:48:36 PM
 User: Kim Johnston

Process Sheet

Customer : QU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 40278	
Estimate Number : 11036	
P.O. Number :	Part Number : D2804041
This Issue : 7/4/2008 S.O. No. :	Drawing Number : D2804 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 34325	Material :
Written By : <u>[Signature]</u>	Due Date : 7/18/2008 Qty: 10 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM	
Est Rev G As per Rev C 06-11-08 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D28041	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STA 155 Bracket

Pick:

Qty Part Number	Description	Batch
1 D2804-1	Bracket	B 40279 *

SB 08/07/17 (10)

2.0	D28051	Stop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Stop

Pick:

Qty Part Number	Description	Batch
1 D2805-1	Stop	B35852

SB 08/07/17 (10)

3.0	D2809	Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	B 35631

SB 08/07/17 10

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Press D2805-1 Into arm as per Dwg D2804

SB 08/07/17 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 12:48:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 40278

Part Number: D2804041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/18 (10)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

7:30am

OVEN TEMPERATURE:

320°F

FINISH TIME:

8:00am

JB

08-07-18

(10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR

08-07-18

(10)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2804

SJS 08/07/18

(10)

9.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3C16A

Bolt

105426

JB

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

2

MS21043-3

Nut

M108558

JB 8/7/18 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 12:48:36 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 40278

Part Number: D2804041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty Part Number Description

Batch 107101 4 NAS1515H3

Washer

~~M 104929~~

A/R LPS-3

Corrosion Spray M 104929

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

SB 08/07/18

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/18 (10)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 8/2/17 (10)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

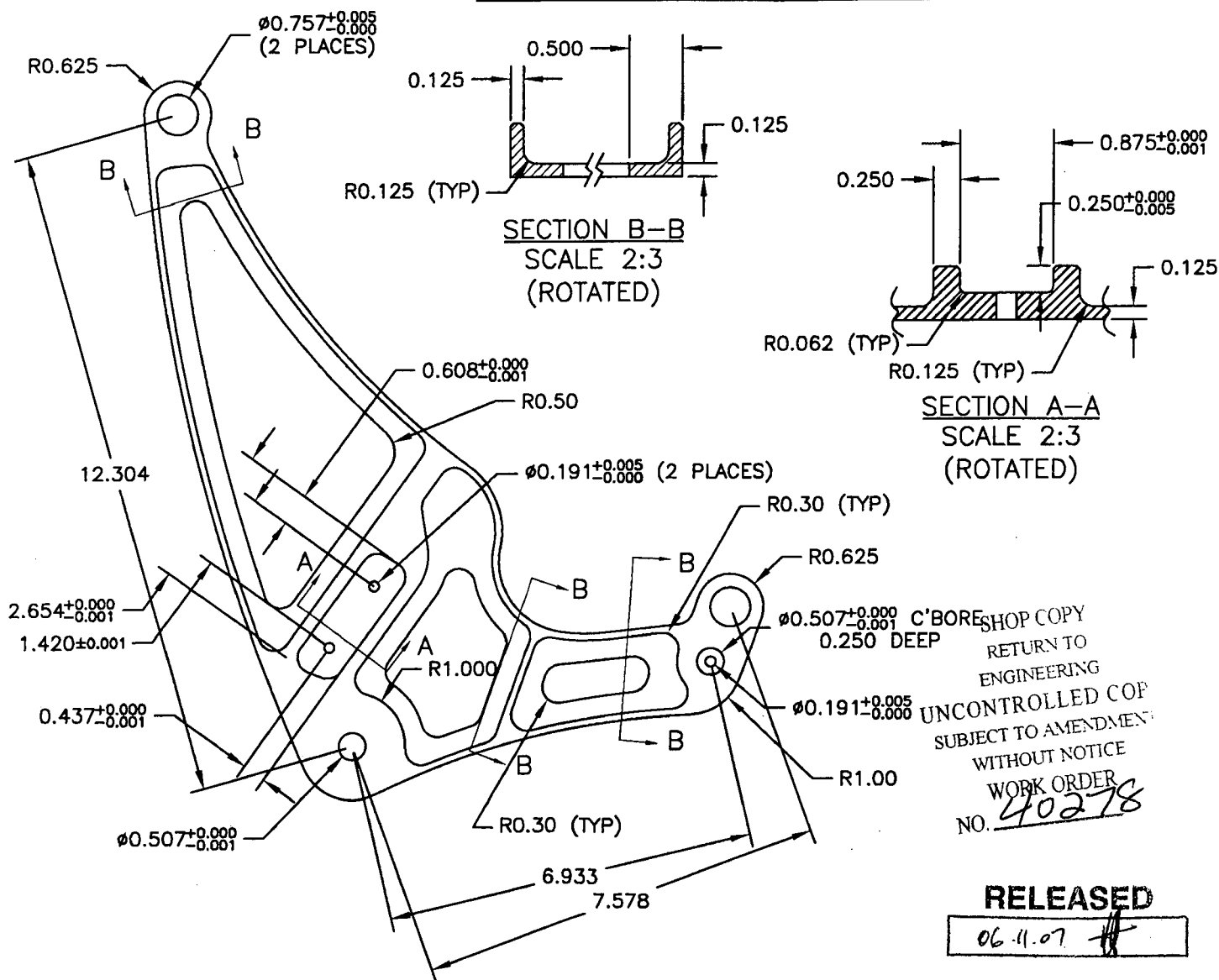
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16	TITLE STA 155 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

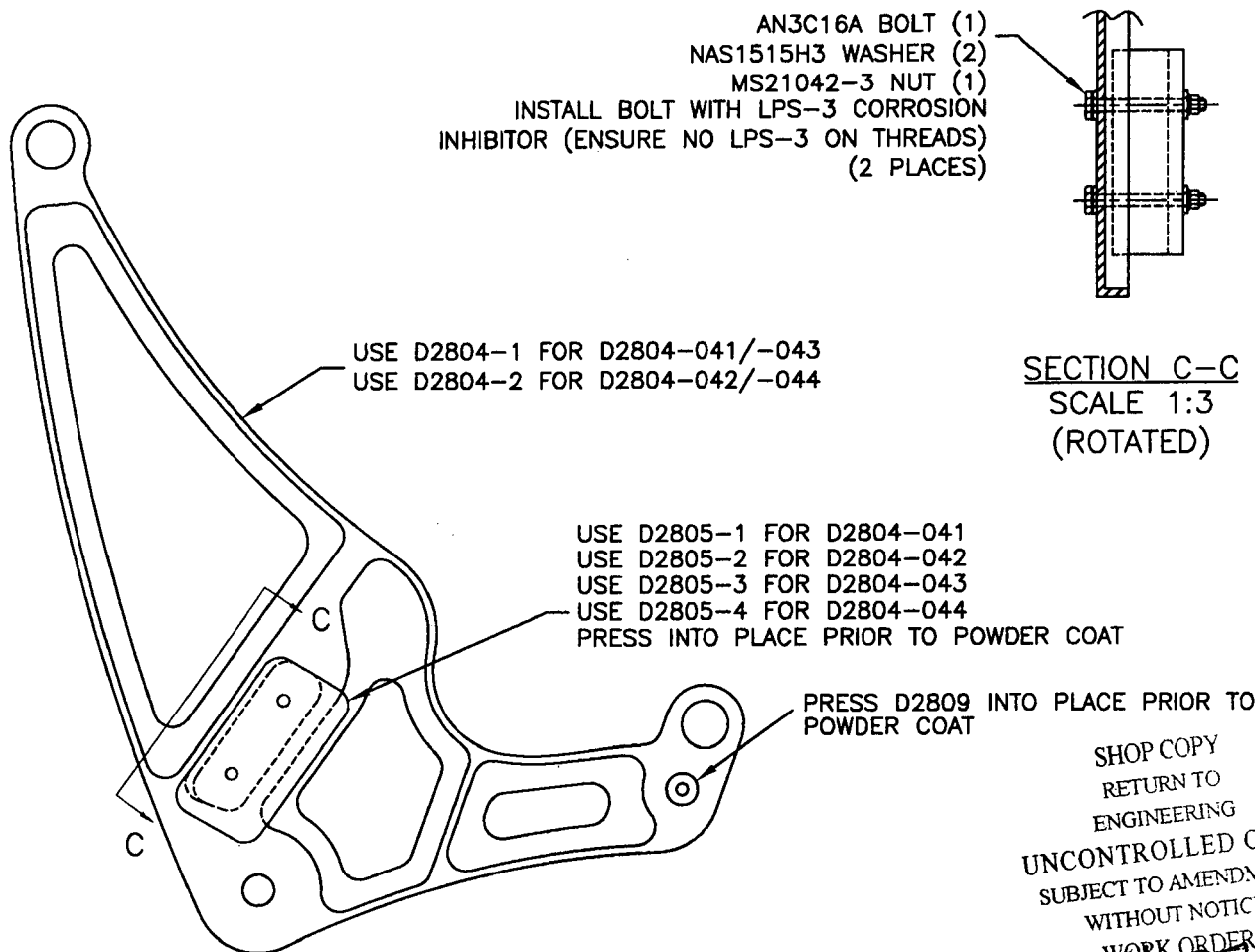
- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16	TITLE STA 155 BRACKET		SCALE 1:3



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40578

RELEASED

06.11.07 [Signature]

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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